

Date: Friday, 12/7/2007 10:21:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM WELDMENT
Job Number : 36189	
Estimate Number : 12104	
P.O. Number : N/A	Part Number : D3354043
This Issue : 12/7/2007 S.O. No. : N/A	Drawing Number : D3354 REV B OK PER HAND CHANGES 07.12.07 DC
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 34621	Material : N/A
	Due Date : 1/10/2008
Written By : <u>JA 07.12.07</u>	Qty: 4 Um: Each
Checked & Approved By : <u>JA 07.12.07</u>	
Comment : est rev A 06.01.25 new issue EC	
est rev B 07.05.14 rev B dwg Ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33543	shaft
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description
1	D3354-3	shaft

batch B 36232 → 2x ✓
 B31586 → 2x ✓
 cabrz

07/12/19 (4x)

2.0	D33545	right arm
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description
1	D3354-5	right arm

batch B34634 N/A ✓

07/12/19 (4x)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354 ✓

2-Grind welds flush as per dwg D3354 ✓

07/12/19 (4x)

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

07.12.19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:21:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 36189

Part Number: D3354043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



~~QC5 STD~~ (4)



Comment: INSPECT WORK TO CURRENT STEP

QC5-5 07/12/19 (X6)

6.0

POWDER COATING

POWDER COATING



M 18052



(4X)

Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M-1 07/12/20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ND



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-20

(4X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST994

JP AS 07/12/20

(4X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/21

Job Completion



mi 2007/12/21

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

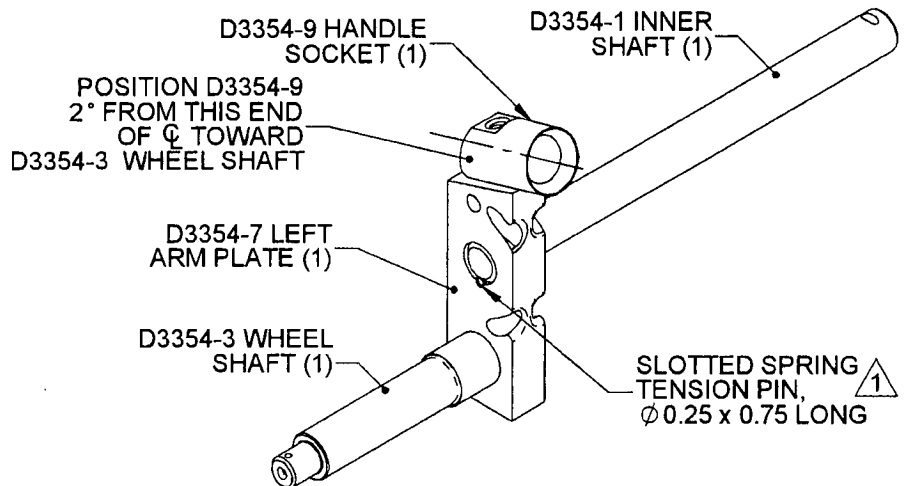
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07.12.06 DC

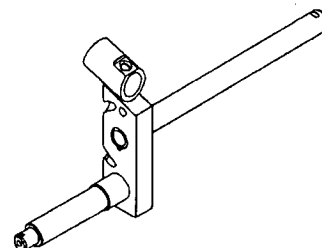
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CHANGES ON
P. 5 & 6
07.12.07
DC

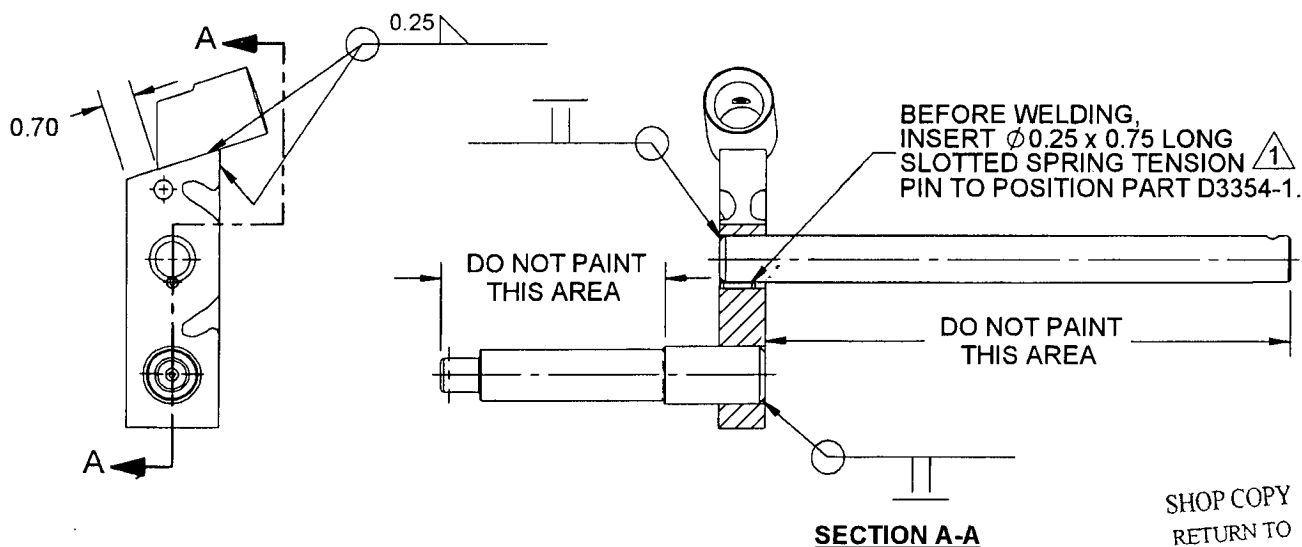
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DATE 07.02.02	TITLE D3354	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	



D3354-041 LEFT ARM WELDMENT



**D3354-042 MIRROR
ARM WELDMENT**



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

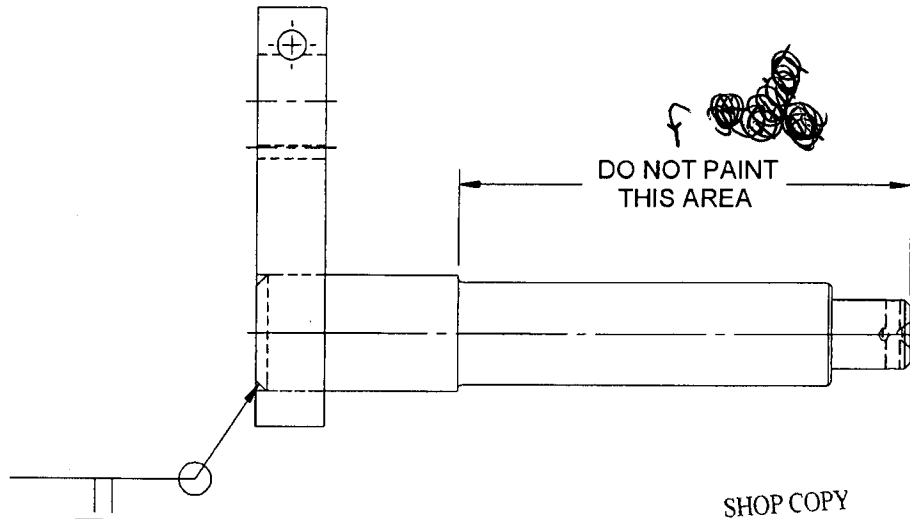
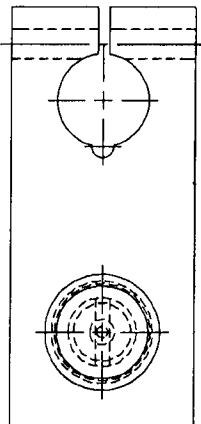
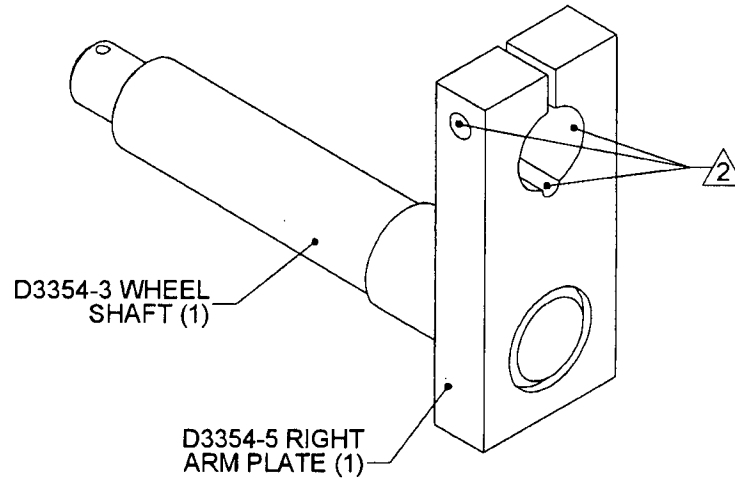
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
*07.02.02***UNDER REVIEW***07.12.06 DC**OK PER HAND
CHANGES ON P. 586**07.12.07 DC***D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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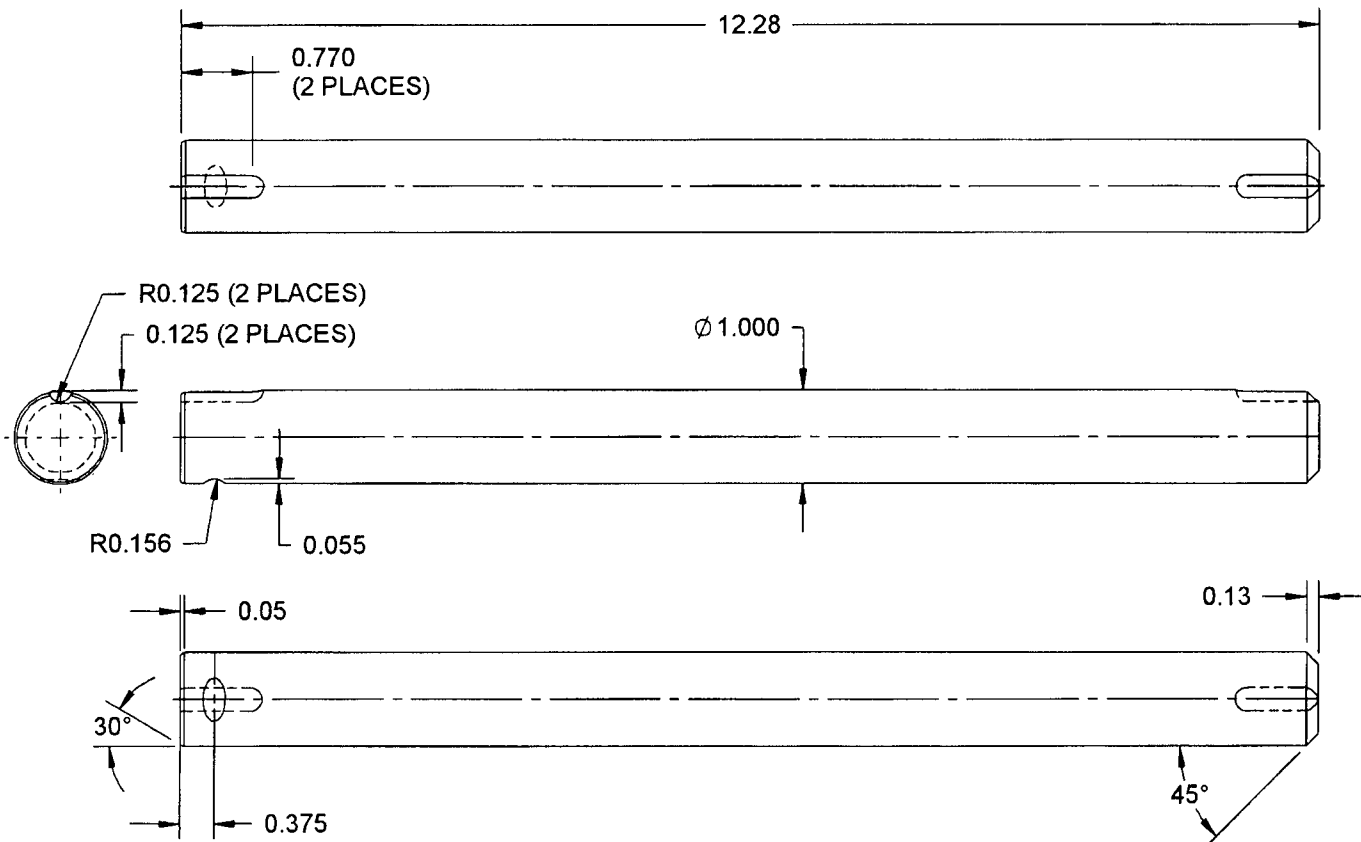
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

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[Signature] 07.02.02

UNDER REVIEW

07.12.06 *dc*

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CHANGES ON
P. 586 07.12.07 *dc*



D3354-1 INNER SHAFT

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NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS# G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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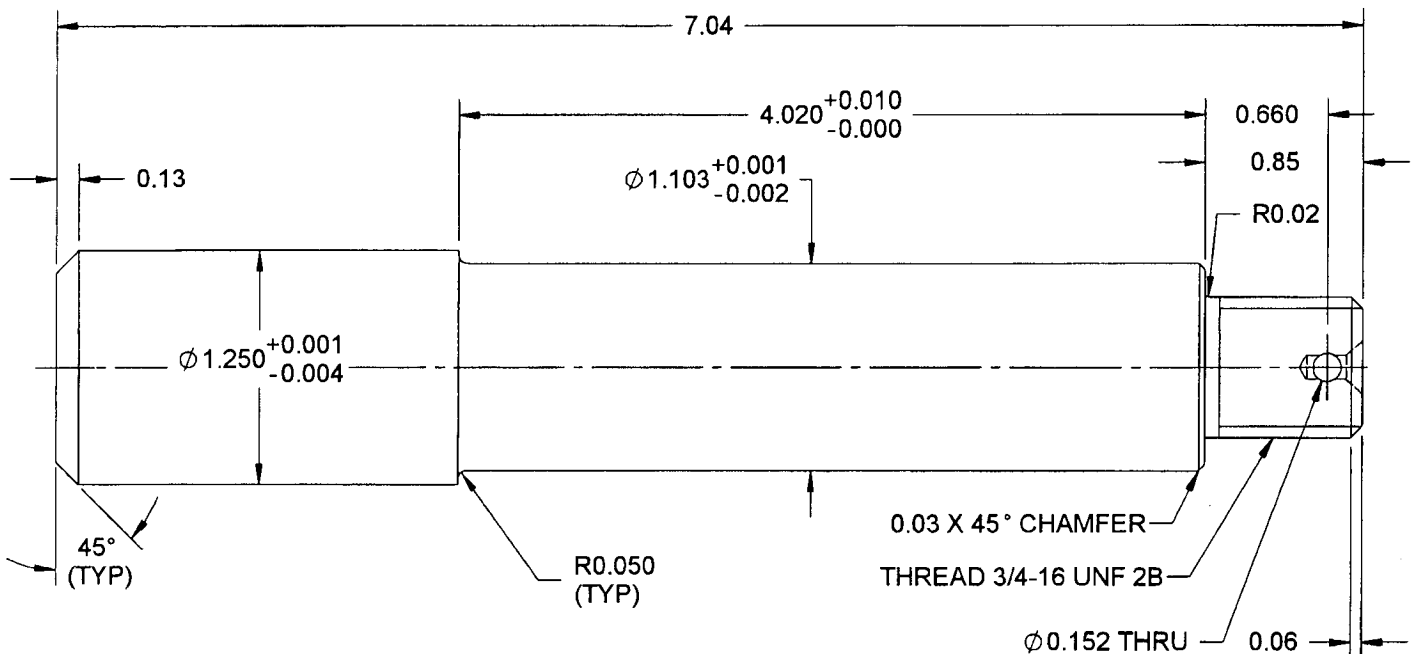
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

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07.12.06 DC

OR PER HAND
CHANGES ON P. 586
07.12.07 DC**D3354-3 WHEEL SHAFT**SHOP COPY
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NO. 36189**NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS# G41400 ROUND BAR, ϕ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 07.02.02	TITLE LEFT ARM WELDMENT	SCALE 1:1	

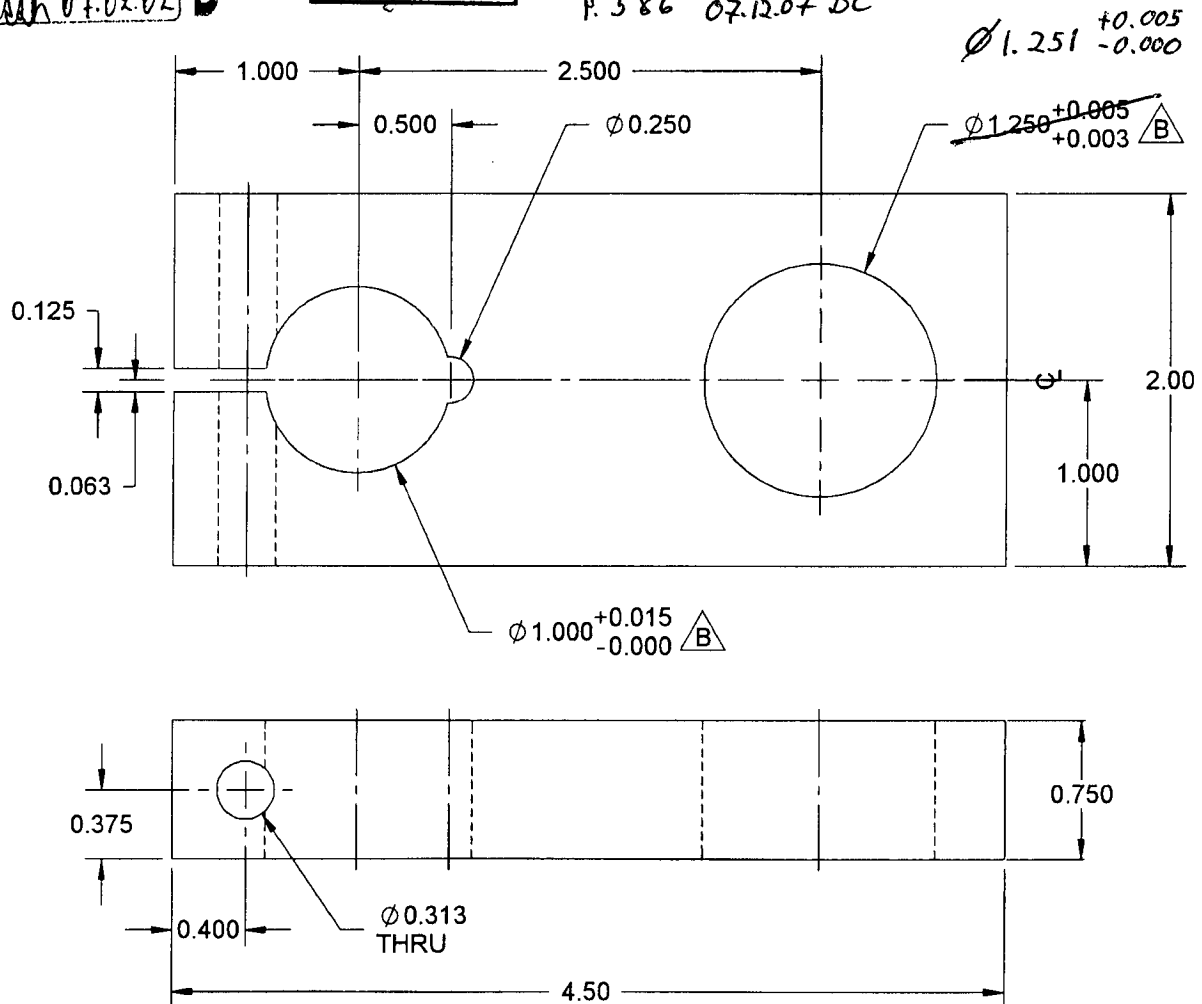
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CHANGES ON
P. 586 *07.12.07 DC*

07.12.07 DC



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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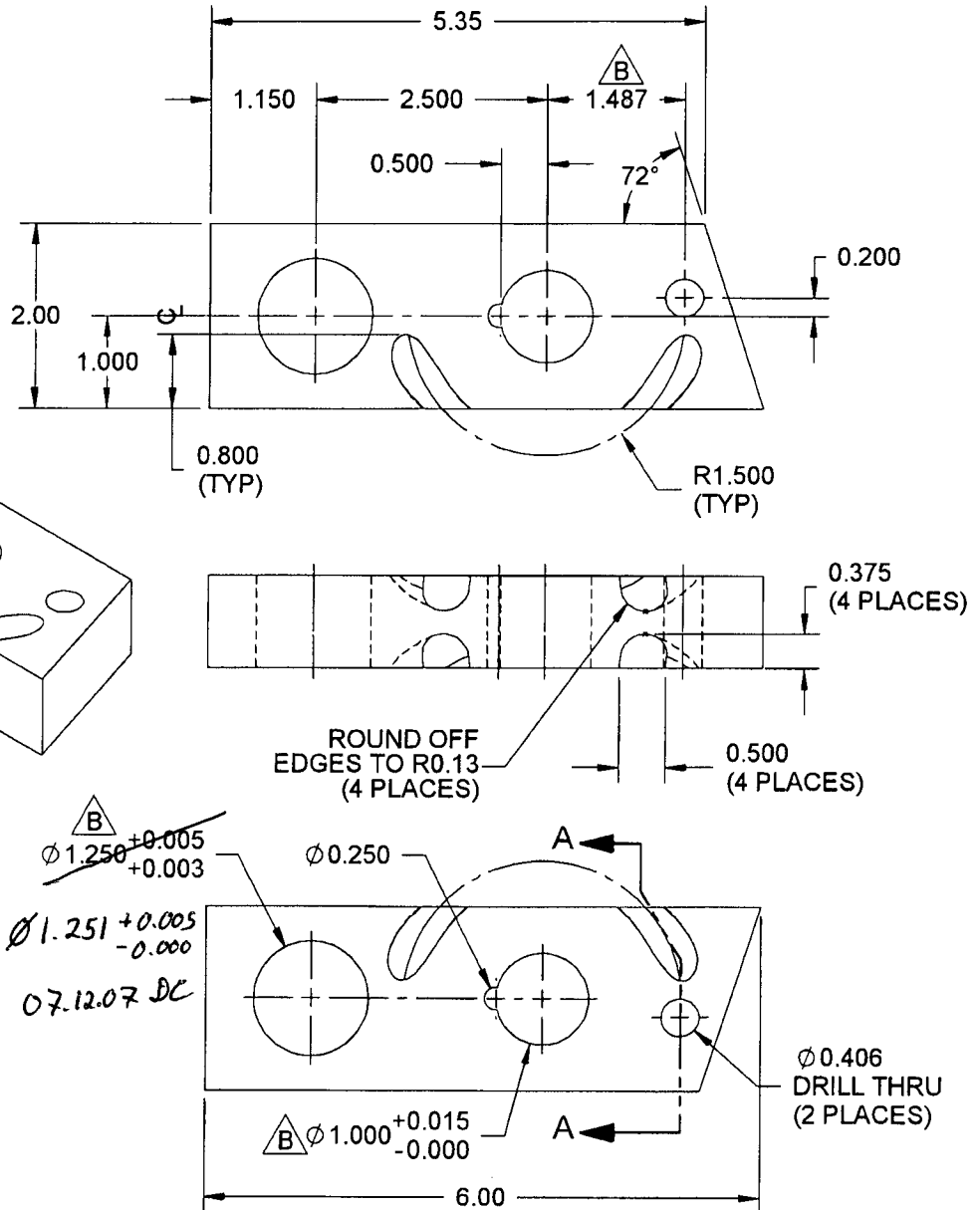
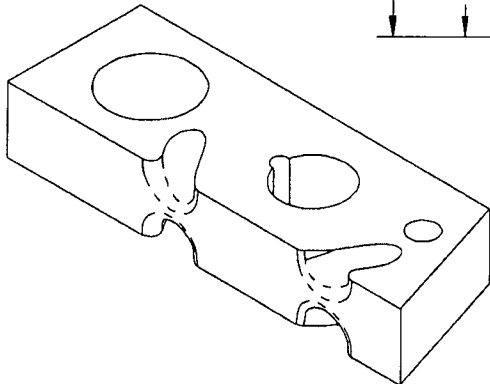
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

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[Stamp] 07.02.02**UNDER REVIEW**

07.12.06 DC

OK PER HAND CHANGES
ON P. 586
07.12.07 DC**SECTION A-A****D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

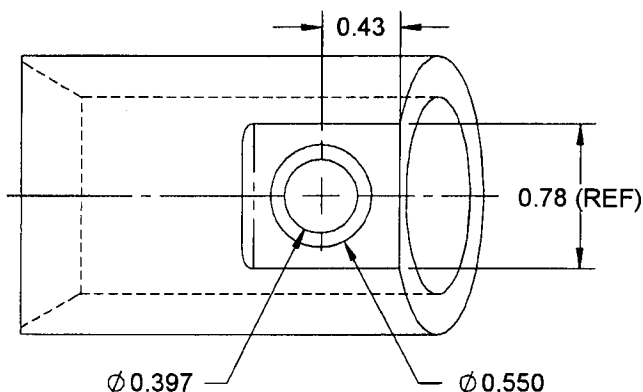
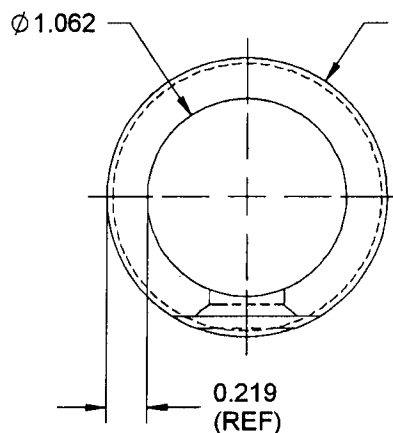
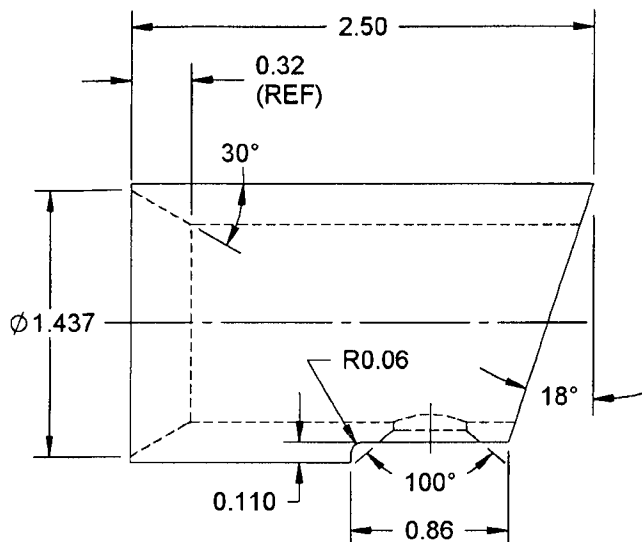
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:1



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07.12.06 DC

OK PER
HAND CHANGES
ON P. 5 & 6
07.12.07 DC

D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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